

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001840**Date Inspected:** 03-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Meng Linnan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Orthotropic Box Girders (OBG).

Bay 1 OBG:

The QA Inspector randomly observed the Gas Metal Arc Welding (GMAW) of the closed rib Production Monitoring Test (PMT), for Deck Plates DP027-001 and DP065-001 per ZPMC Weld Procedure Specification (WPS) WPS-B-T-2342-U1(URib)-3. The QA Inspector randomly observed that each of the 3 ribs on the PMT Assembly, were welded individually.

The QA Inspector randomly observed the GMAW of the closed ribs on Deck Plate DP065-001 per ZPMC WPS WPS-B-T-2342-U1(URib)-3. The QA Inspector randomly observed ZPMC CWI Meng Linnan monitoring and recording weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them on a separate spreadsheet. The attached photograph provides additional detail.

The QA Inspector randomly observed the GMAW of the closed ribs on Deck Plate DP027-001 per ZPMC WPS WPS-B-T-2342-U1(URib)-3. The QA Inspector randomly observed ZPMC CWI Meng Linnan monitoring and recording weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them on a separate spreadsheet.

The QA Inspector randomly observed the Submerged Arc Welding (SAW) of the closed rib PMT, for Deck Plates

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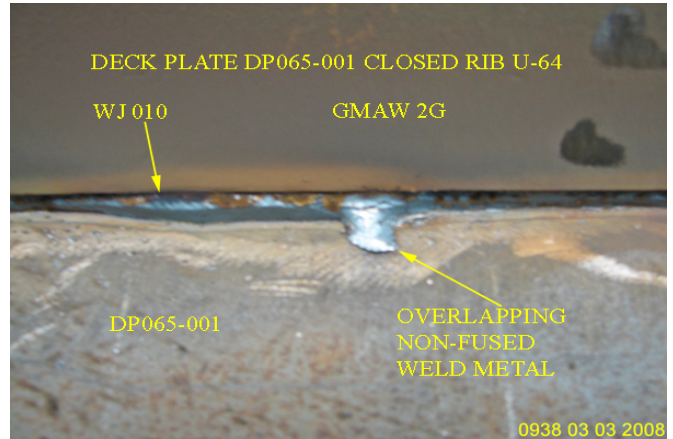
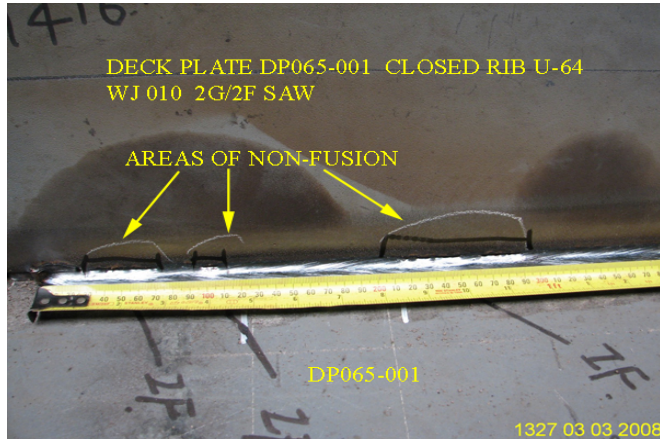
## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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DP027-001 and DP065-001 per ZPMC WPS WPS-B-T-2342-U1(URib)-3. The QA Inspector randomly observed that each of the 3 ribs on the PMT Assembly, were welded individually.

The QA Inspector randomly observed the SAW of the closed ribs on Deck Plate DP065-001 per ZPMC WPS WPS-B-T-2342-U1(URib)-3. The QA Inspector randomly observed ZPMC CWI Meng Linnan monitoring and recording weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them on a separate spreadsheet. The attached photograph provides additional detail.



### Summary of Conversations:

There were no relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Franco,Charlie	Quality Assurance Inspector
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<b>Reviewed By:</b>	Hager,Craig	QA Reviewer
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